

Wednesday, August 12, 2015 4:04:04 PM

135561

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Tail Rotor Pedal Lockout

Start Date: 8/05/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/12/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS Date: AUG 17 2015 Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D119-827	D

100	Document Control	0.00
-----	------------------	------

100

DC

Doc.Control -USB or Paperwork

Document Control
DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D119-827-011 CHG002

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Packaging

Pick Kit

Memo

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

**AS
27
9-89**

SEP 30 2015

DAS
02
9-89

SEP 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
QC / QA Coordinator Approval																					
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Work Order ID 135561

Wednesday, August 12, 2015 4:04:04 PM

135561

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lockout

Start Date: 8/05/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-827-011

Location: 121

DAS

02

9-89

SEP 30 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ OCT 01 2015MLJ OCT 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Wednesday, August 12, 2015 4:04:03 PM

Page 1

Work Order ID: 135561

135561

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 8/05/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP
REV:B 13-01-09 REV B JLM VERIFIED:DD IPP REV:C
12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041		Manufactured	No			110	Each	0.0000	1	1			
D4704-041	DAS								**				
Expandable Pin Assembly	02												
D4703-041	9-89	Manufactured	No			110	Each	2.0000	2	2			
D4703-041	DAS								**				
Lock Pin Assembly	02												
	9-89												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST123			2						
				127873			2						
D4710-1		Manufactured	No			110	Each	7.0000	1	1			
D4710-1	DAS								**				
Spacer	02												
	9-89												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST123			7						
				127249			7						
D4721-1		Manufactured	No			110	Each	4.0000	1	1			
D4721-1	DAS								**				
Decal	02												
	9-89												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST121			4						
				127250			4						

SEP 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 135561

135561

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 8/05/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

AN4-11A Purchased No

AN4-11A

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

FG 20
120731 20
ST325A 52
M128362 52

**

DAS
27
9-89

DAS
6
9-89

MS14144L4 Purchased No

MS14144L4

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

ST316 24
m132680 24

**

DAS
27
9-89

DAS
6
9-89

MS24665-153 Purchased No

MS24665-153

Cotter Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

ST294 79
107139 79

**

DAS
27
9-89

DAS
6
9-89

NAS1149D0416J Purchased No

NAS1149D0416J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

GA 374
m131511 374
ST270 4340
m131511 4340

**

DAS
27
9-89

DAS
6
9-89

SEP 30 2015

Wednesday, August 12, 2015 4:04:04 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, August 12, 2015 4:04:04 PM

Page 3

Work Order ID: 135561

135561

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 8/05/15

Required Date: 8/12/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,062.000

8

8

NAS1149D0463J

WASHER

133077X6

DAS

27

9-89

DAS

6

9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

2021

M127904

20

M129682

86

M130799

371

M132035

1419

M132317

125

2

NAS6604D16

Purchased

No

110

Each

41.0000

2

2

NAS6604D16

Bolt

DAS
02
9-89

2

Location

Loc Qty

Loc Code

ST262

41

m131616

41

DAS

27

9-89

DAS

6

9-89

SEP 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

4.0 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

The following are the net weight increases associated with D119-827-011 kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 ON A109/A119 MODELS	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 ON 206/407 MODELS	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg